

# Work Order ID 52389

Tuesday, September 22, 2009 11:17:10 AM



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Item ID:	D2565-205	Accept		Setup	Start	
Revision ID:	E				Stop	
Item Name:	Strut					
Start Date:	9/23/2009	Start Qty:	<u>2.00</u>	Cust Item ID:		
Required Date:	10/9/2009	Req'd Qty:	4.00	Customer:		
Reference:						

Approvals:	Process Plan:	<u>RL</u>	Date:	<u>09-9-22</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2565	Rev E								

100		0.00							
	NC BRAKE								
Brake NC	Memo	0.00							
Brake NC	Punch as per Dwg D2565 using DT 8313								

SB 09/10/09

8 8

110		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Drill hole as per Dwg D2565 (one end only)								

Deburr and polish M-L 09/10/13

82

120		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

27 S 09/10/13

28

[illegible]

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**Accept**

**Setup Start**

**Stop**

**Item Name:** Strut

██████████  
██████████  
██████████  
██████████  
██████████

**Cust Item ID:**

**Required Date:** 10/9/2009      **Req'd Qty:** 4.00

**Customer:**

**Reference:**

Run Start

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

**Stop**

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Insp.  
Stamp**

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

$\Rightarrow$  09/10/14

0.00

### Powdercoat

## Memo

## Powder Coating

START TIME: 7:00 AM OVEN TEMPERATURE: 400°F  
FINISH TIME: 7:30 AM

### QC3- Inspect Part Finish

0.00

BR 09-10-14

0.00

QC

## Memo

## Quality Control

Identify as per dwg & Stock Location: 283

0.00

### Packaging

## Memo

0.00

## Packaging



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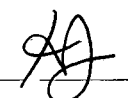


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Item ID: D2565-205 Accept  Setup Start   
Revision ID: E Stop   
Item Name: Strut  
Start Date: 9/23/2009 Start Qty: 4.00  Cust Item ID:  
Required Date: 10/9/2009 Req'd Qty: 4.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

09/10/15 

MF 09-10-25

# Picklist Print

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Work Order ID: 52389



Parent Item: D2565-205RevE



Parent Item Name: Strut

Start Date: 9/23/2009

Required Date: 10/9/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			100	f	286.3500	7.5436			
304 RD Tube .750 x .049W												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

286.35

107518

2.77

108498

0

109314

8.5

110113

0.73

110271

0.03

111096

9

111457

11.43

112652

253.89

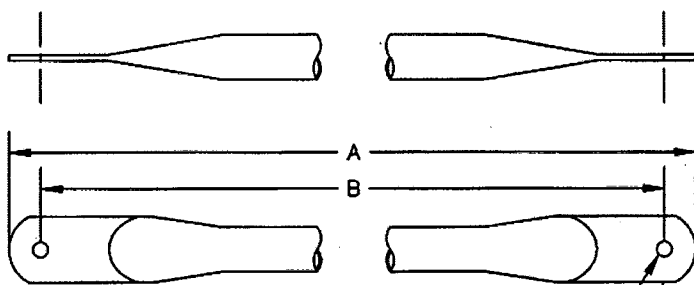
8/25 09/10/09

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DESIGN	DRAWN BY	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2565	REV. E SHEET 1 OF 1
DATE 04.05.05		TITLE STRUT	SCALE 1:3
A	96.05.03	NEW ISSUE	
B	97.03.15	CORRECT D2565-111 DIM. A	
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)	
D	02.06.05	ADD -3XX PARTS; ADD FINISH	
E	04.05.05	ADD D2565-401-411; RMV ANGLE D	

**RELEASED**  
04.05.05



DIA 0.257 TO BE PUNCHED  
"C" DIA TO BE OPENED MANUALLY

PUNCH ENDS PER SPEC CONTROL DRAWING D2638

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 52389

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

#### GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL  
(REF DART SPEC. M304TR0.750W0.049)  
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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